



Date: Tuesday, 8/7/2007 7:33:39 AM
User: Jean-Luc Menard



Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: "T" HANDLE ASSEMBLY
Job Number	: 33831		
Estimate Number	: 11179		
P.O. Number	: N/A	Part Number	: D2282041
This Issue	: 8/7/2007 S.O. No. : N/A	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 8/7/2007 Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 33390A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 8/14/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	50 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :								
1.0	D22823	Tube								
										
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>1</td><td>D2282-3</td><td>Handle tube</td><td><u>333829</u></td></tr> </table> <p style="text-align: right;"><i>[Signature]</i> 07/08/07 (50)</p>			Qty	Part Number	Description	Batch	1	D2282-3	Handle tube	<u>333829</u>
Qty	Part Number	Description	Batch							
1	D2282-3	Handle tube	<u>333829</u>							

2.0	D22825	Tube								
										
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>1</td><td>D2282-5</td><td>Handle tube</td><td><u>334116</u></td></tr> </table> <p style="text-align: right;"><i>[Signature]</i> 07/08/07 (50)</p>			Qty	Part Number	Description	Batch	1	D2282-5	Handle tube	<u>334116</u>
Qty	Part Number	Description	Batch							
1	D2282-5	Handle tube	<u>334116</u>							

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1-Weld as per D2282-041 'T' Handle Assembly</p> <p>Grind chamfers and ensure full penetration.</p> <p>A/R ER316L SS Filling Rod <u>M18712</u></p> <p>Dwg Rev: <u>E</u></p> <p style="text-align: right;"><i>[Signature]</i> 07-08-07 (50)</p>		

4.0	DO NOT USE <u>Q29</u>	WELD INSPECTION
		
<p>Comment: WELD INSPECTION</p> <p style="text-align: right;"><i>[Signature]</i> 07/08/07 (50)</p>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 33831

Part Number: D2282041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SA 07.08.05

(50)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.08.08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/08 (52)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion



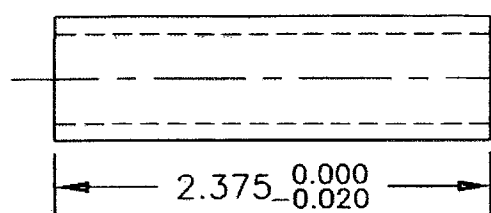
07/08/09



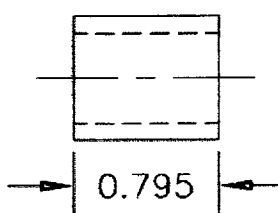
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

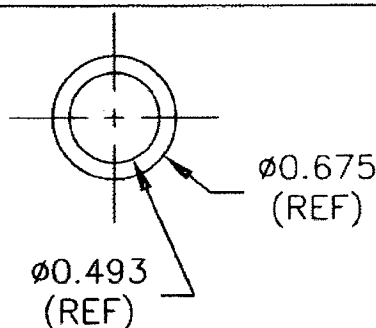
05/09/16



D2282-3

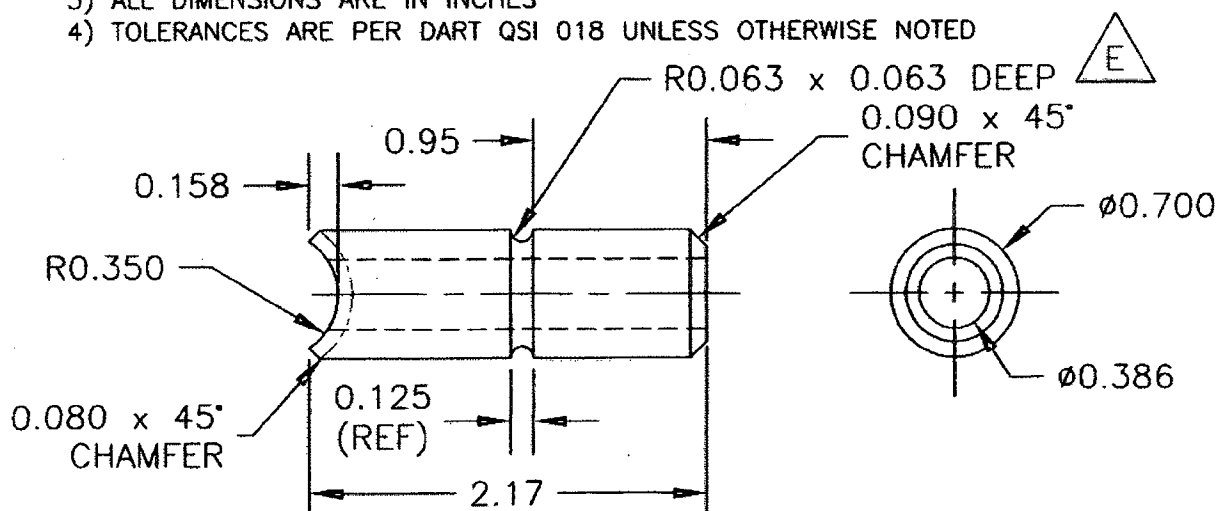


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

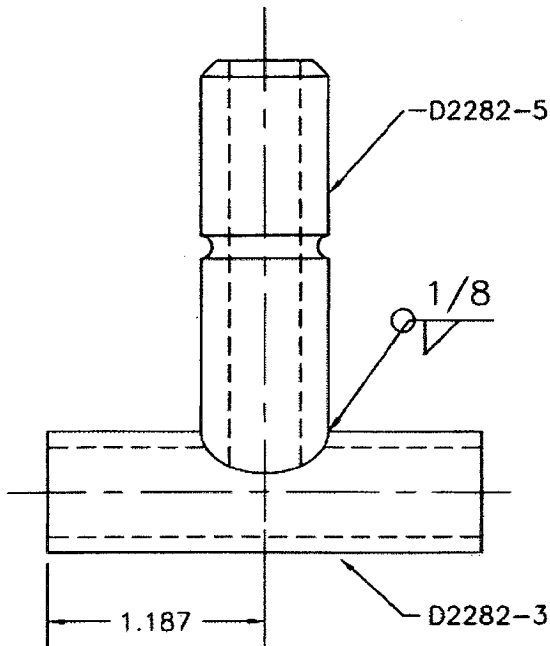


Copyright © 1994 by DART AEROSPACE LTD

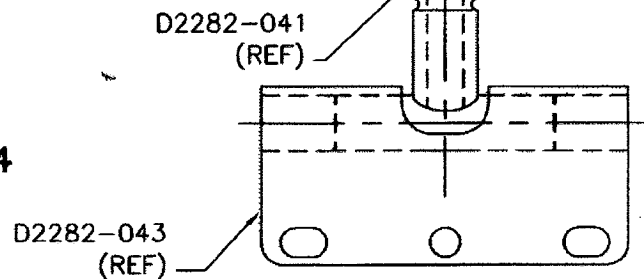
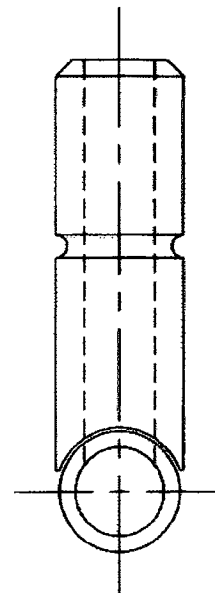
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



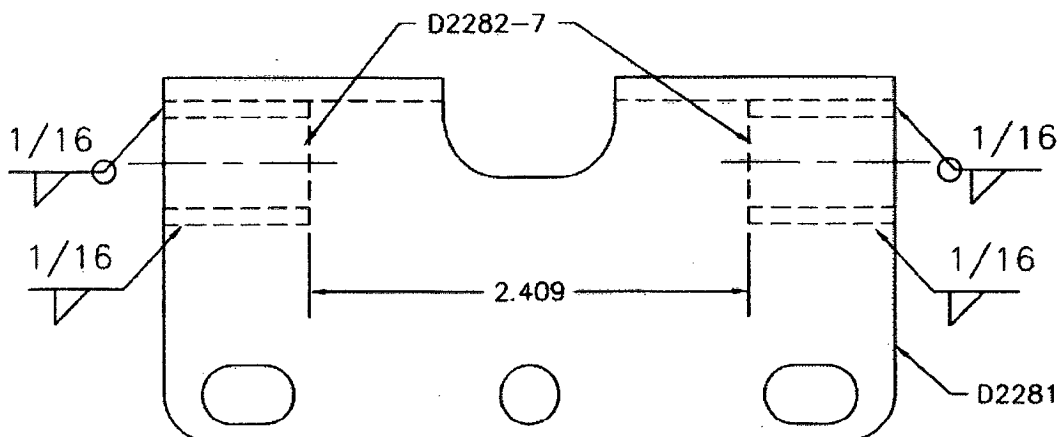
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.